

Date: Friday, 04/04/2008 7:37:15 AM
 User: Jean-Luc Menard

Process Sheet

| | | | |
|-----------------------|---|------------------|-------------------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : WEAR PLATE |
| Job Number | : 38331 | | |
| Estimate Number | : 11232 | | |
| P.O. Number | : | Part Number | : D2365 |
| This Issue | : 04/04/2008 S.O. No. : | Drawing Number | : D2365 REV C |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : 02/04/2008 Type : MACHINED PARTS | Drawing Revision | : C |
| Previous Run | : | Material | : |
| Written By | : <u>PL/08.04.04</u> | Due Date | : 09/04/2008 Qty: 20 Um: Each |
| Checked & Approved By | : | | |
| Comment | : Est Rev A Removed from 9 Digit 05-12-05 JLM | | |
| | : Est Rev.B Now On Waterjet 08-04-04 JLM | | |
| | : Verified By:EC | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|-------------|--------------------|
| 1.0 | M6061T6S063 | 6061-T6 .063 Sheet |
|-----|-------------|--------------------|



Comment: Qty.: 0.0049 sf(s)/Unit Total : 0.0987 sf(s)
 Material: 6061-T6 (QQ-A-250/11) 0.063" thick
 (M6061T6S.063)
 Batch: 107276 IB 8-4-4

| | | |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET
 1-Cut as per Dwg D2365
 Dwg Rev: C
 Prog Rev: C

IB 8-4-4(30)

2-Deburr if necessary

08/04/04 (30)

| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|

IB 8-4-4

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

08/04/04 (30) counter

| | | |
|-----|-----------------|----------------------------|
| 5.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1 |
|-----|-----------------|----------------------------|



Comment: HAND FINISHING RESOURCE #1
 Chemical Conversion Coat as per QSI 005 4.1

FD 08/04/07 (30)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEAR PLATE

Job Number: 38331

Part Number: D2365

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



30

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DL 08-04-07

7.0

FE832EF

PEM Insert



Comment: Qty.: 2.0000 Each(s)/Unit Total : 40.0000 Each(s) 60

Pick:

Qty Part Number Description Batch

2 FE832EF PEM Insert M101634

✓ ml 08/04/08

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



X30

Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Insert as per Dwg D2365

ml 08/04/08

9.0

QC5

INSPECT WORK TO CURRENT STEP



counts

Comment: INSPECT WORK TO CURRENT STEP

5 08/04/08 X30

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 35

AS 08/04/08 X30

11.0

QC21

FINAL INSPECTION/W/O RELEASE



08/04/10

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

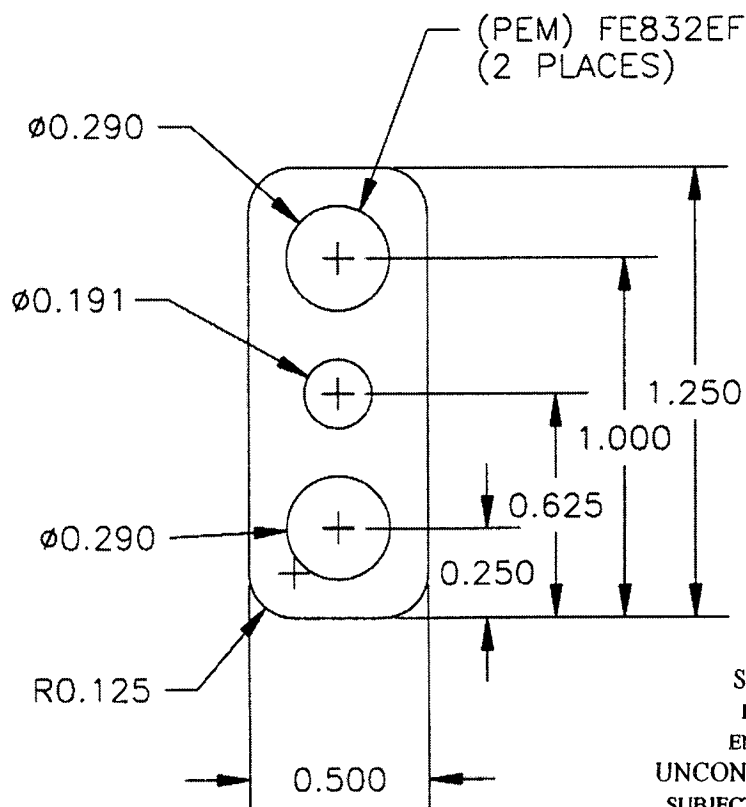


W ml 08-04-09



| | | | |
|------------------|-------------------------|--|--------------|
| DESIGN | DRAWN BY | DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA | |
| B WILLIAMS | B WILLIAMS | DRAWING NO. | REV. C |
| CHECKED Bw | APPROVED [Signature] | D2365 | SHEET 1 OF 1 |
| DATE 95:01:20 | TITLE WEAR PLATE | | SCALE 2:1 |
| C | 95:03:06 | 0.191 WAS 0.197 | |

RELEASED
17/04/22 DS



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 3833

6061-T6 (00-A-250/11) 0.063 THICK } # 00.09.26
ACID ETCH & ALODINE PER QSE D05 4.1-1 } #
INSTALL FE832EF (2 PLS) AFTER ALODINE } # 00.03.07
~~ALSI 304/316 SS~~
MATERIAL: 6061-T6 ALUMINUM 0.063 THICK, ANODIZE BLACK.
AFTER ANODIZING INSTALL (PEM FE832EF) 2 PLACES } #